PRELIMINARY ISSUE

Work Order ID 61944-

Monday, September 13, 2010 8:18:27 AM

Item ID: D4172-9
Revision ID: PRELIM
Item Name: Angle

Accept

Setup Start

Stop

split 5

Start Date: 9/10/2010 **Start Qty:** 6.00
Required Date: 9/17/2010 **Req'd Qty:** 6.00
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** [signature] **Date:** 10-9-13 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4172 / Revision Nbr: PA1									
100 Small Fab		0.00							
Small Fab	**Memo** 1- Cut to lenght as per dwg 2- Use DT9662 to drill holes in angle, open to size as per dwg 3- Deburr holes	0.00							
110 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	**Memo**	0.00							
120 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	**Memo**	0.00							

10/05/16 6

- inspector to PA1 Dwg only 10/07/16 X6

10/09/16 X6 6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61944

Monday, September 13, 2010 8:18:27 AM

Item ID: D4172-9
Revision ID: PRELIM
Item Name: Angle

Start Date: 9/10/2010 **Start Qty:** 6.00
Required Date: 9/17/2010 **Req'd Qty:** 6.00
Reference:

Accept

Setup Start

Stop

Cust Item ID:
Customer:

Run Start

Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00				6	0		
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: CA	0.00							
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10-9-10 Dan

RT 10-09-29 (x5)

10/09/29

10.09.23

POSITIVE RECALL
EFFECTIVE 10-27-13 AUTH
RELEASED DATE 10.09.29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 13, 2010 8:18:31 AM

Work Order ID: 61944

Parent Item: D4172-9

Parent Item Name: Angle

Start Date: 9/10/2010 **Required Date:** 9/17/2010

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6203 Angle Extrusion		Manufactured	No			100	f	9.5000	0.0625	0.394737			

Location	Loc Qty	Loc Code
MAT	9.5	
45501	9.5	

10/09/15

0.394737

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	B6194
Description: Pod mounting Frame Assy. Angle	Part Number:	D4172-9
Inspection Dwg: D4172 Rev: PA1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.098"	+.005" -.001"	.100"	✓		Vern. ED-14	
Ø.281"	±.005" ±.001"	.282"	✓		4	
.563"	±.010"	.563"	✓		4	
.450"	±.010"	.455"	✓		4	
.281"	±.010"	.280"	✓		4	
.978"	±.010"	.978"	✓		4	
0.750"	±.010"	.750	✓		Vern ED-14	
0.05"	±.010"	.05	✓		4	
1.500"	±.010"	1.50	✓		4	

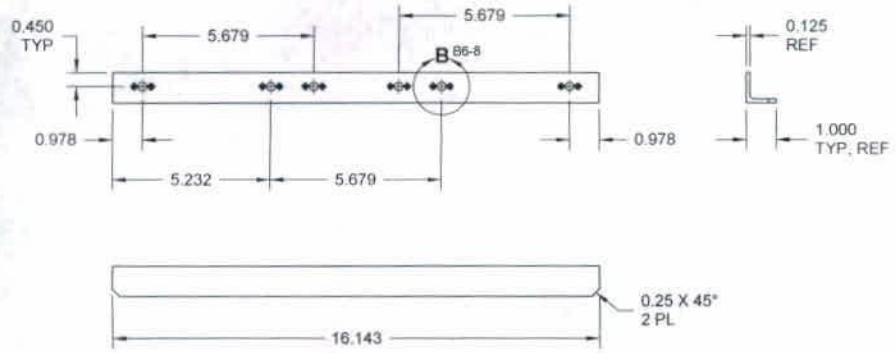
Measured by:	EB
Date:	10/09/16

Audited by:	[illegible]
Date:	10/09/16

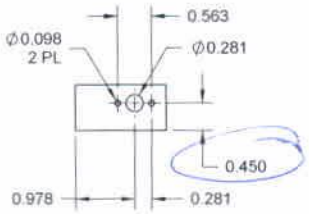
Prototype Approval:	N/A
Date:	N/A

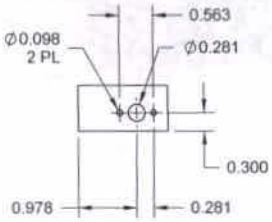
Inspection to Part Dwg only

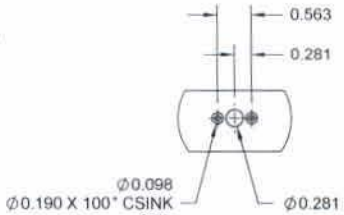
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



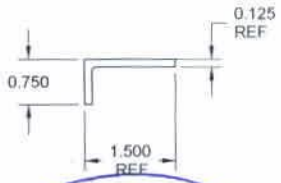
D4172-7 CROSSBAR



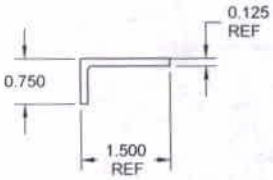




DETAIL B D6-8
SCALE 2X
TYP



D4172-9 ANGLE



D4172-10 ANGLE

PRELIMINARY ISSUE
10.09.08

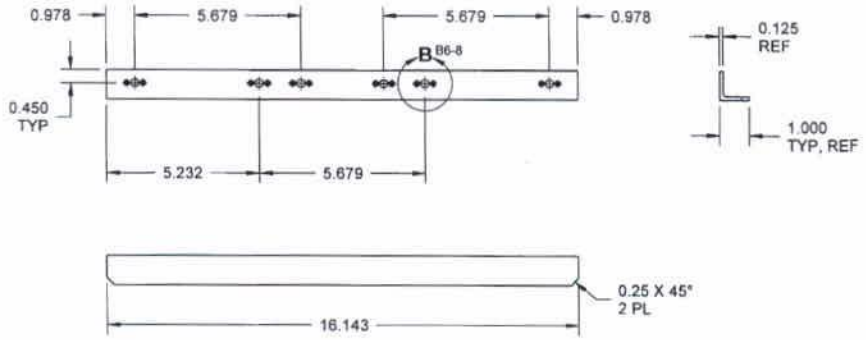
NOTES:
1) MATERIAL
D4172-7: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.00 X 1.00 X 0.125 THICK
PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A OR D6207
D4172-9/-10: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.50 X 1.50 X 0.125 THICK
PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A OR D6203
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
7) WEIGHT: D4172-7 = 0.14 lbs; D4172-9/-10 = 0.01 lbs EACH

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WORK ORDER
NO 4944

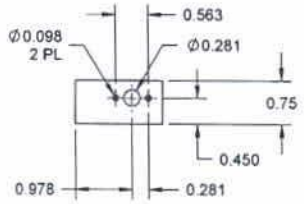
BJ 10-9-13

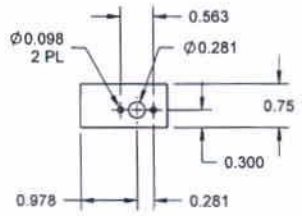
DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4172 REV. PA1
MFG. APPR.		SHEET 8 OF 8
APPROVED		TITLE POD MOUNTING FRAME ASSY SCALE NTS
DE APPR.		
DATE 10.09.03		

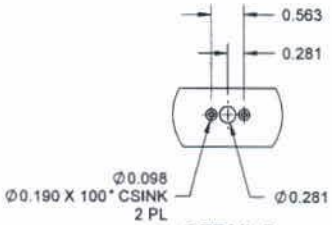
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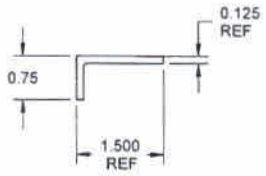
D4172-7 CROSSBAR



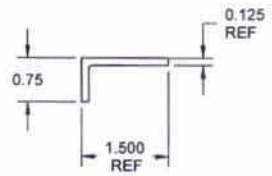




DETAIL B D6-8
SCALE 2X
TYP



D4172-9 ANGLE



D4172-10 ANGLE

NOTES:
1) MATERIAL
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3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: D4172-7 = 0.14 lbs; D4172-9/-10 = 0.01 lbs EACH

619444

RELEASED
2010 -09- 29

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4172 REV. A
MFG. APPR.		SHEET 7 OF 7
APPROVED		TITLE POD MOUNTING FRAME ASSY SCALE NTS
DE APPR.		
DATE 10.09.15		

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